

MIL-B-24222A(SH)
26 June 1978
~~SUPERSEDING~~
MIL-B-24222(SH)
7 April 1967
(See 6.5)

MILITARY SPECIFICATION

BAG, STORAGE, MASK, AIR LINE

This specification is approved for use by the Naval Sea Systems Command and is available for use by all Departments and Agencies of the Department of Defense.

1. SCOPE

1.1 Scope. This specification establishes the requirements for a storage bag for containing an air line mask and hoses.

2. APPLICABLE DOCUMENTS

2.1 Issues of documents. The following documents, of the issue in effect on date of invitation for bids or request for proposal, form a part of this specification to the extent specified herein.

SPECIFICATIONS

FEDERAL

VV-T-295 - Thread, Nylon.
TT-I-1795 - Ink, Marking Stencil, Opaque, (Porous and Non-Porous Surfaces).
PPP-B-636 - Boxes, Shipping, Fiberboards.
PPP-B-640 - Boxes, Fiberboard, Corrugated, Triple-Wall.

MILITARY

MIL-G-16491 - Grommet, Metallic.
MIL-R-17343 - Rope, Nylon.
MIL-C-43006 - Cloth and Strip Laminated, Vinyl-Nylon, High Strength Flexible.

STANDARDS

FEDERAL

FED-STD-595 - Colors.
FED-STD-751 - Stitches, Seams, and Stitching.

MILITARY

MIL-STD-105 - Sampling Procedures and Tables for Inspection by Attributes.
MIL-STD-129 - Marking for Shipment and Storage.
MIL-STD-130 - Identification Marking of U.S. Military Property.

(Copies of specifications, standards, drawings, and publications required by contractors in connection with specific procurement functions should be obtained from the procuring activity or as directed by the contracting officer.)

2.2 Other publications. The following documents form a part of this specification to the extent specified herein. Unless otherwise indicated, the issue in effect on date of invitation for bids or request for proposal shall apply.

UNIFORM CLASSIFICATION COMMITTEE

Uniform Freight Classification Ratings, Rules and Regulations.

(Application for copies should be addressed to the Uniform Classification Committee Agent, G. F. Earl, Tariff Publication Officer, Room 1106, 222 South Riverside Plaza, Chicago, Illinois 60606.)

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to: Commander, Naval Ship Engineering Center, SEC 6124, Department of the Navy, Washington, DC 20362 by using the self-addressed Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter.

MIL-B-24222A (SH)

NATIONAL CLASSIFICATION BOARD

National Motor Freight Classification Classes and Rules.

(Application for copies should be addressed to the ATA Tariff Section, 1616 P Street NW, Washington, DC 20036.)

(Technical society and technical association specifications and standards are generally available for reference from libraries. They are also distributed among technical groups and using Federal agencies.)

3. REQUIREMENTS

3.1 Sample for first article inspection. Prior to beginning production a sample shall be examined as specified in 4.3 (see 6.3).

3.2 Materials.

3.2.1 Vinyl-nylon cloth. The vinyl-nylon cloth shall be type II conforming to MIL-C-43006. The vinyl-nylon cloth shall be either blue for use with a mask and 25 foot hose, or white for use with a mask and a 8-foot hose. The color of the cloth shall be as specified (see 6.2.1).

3.2.2 Thread. Thread used shall be nylon, conforming to type I or II, class 1, size E of V-T-295.

3.2.3 Drawcord. Drawcord shall be approximately 3/16-inch diameter nylon rope conforming to MIL-R-17343.

3.2.4 Grommets. Grommets shall be type III, class 1, size No. 1 conforming to MIL-G-16491.

3.2.5 Reclaimed materials shall be used to the maximum extent possible.

3.3 Dimensions and construction. The bag shall conform in dimensions and construction to the requirement shown on figure 1.

3.4 Stitches. Stitches shall be type 401 of FED-STD-751. There shall be 7 stitches \pm 1 stitch per inch. The ends of all stitching shall be back stitched at least 1 inch.

3.5 Seams. Seams shall be in accordance with FED-STD-751 (see figure 1). Top seam to be type EF5-1, side and bottom seams to be type LSq-2.

3.6 Drawcord. Each bag shall be furnished with a drawcord laced through grommets with each end knotted and of sufficient length to provide 3 inches for knotting as shown on figure 1.

3.7 Identification marking. The words, "U.S.N AIRLINE MASK," shall be stencilled on each bag in the approximate location shown on figure 1. The marking ink used shall conform to TT-I-1795. The color of markings shall be yellow color No. 33538 of FED-STD-595. The marking shall conform to MIL-STD-130.

3.8 Identification tag. Each bag shall be identified by an appropriate tag attached to the drawcord. Information on the tag shall be in accordance with MIL-STD-129.

3.9 Workmanship. The finished storage bags shall be free of defects affecting serviceability or appearance. Details of manufacture shall be in accordance with high grade commercial practice. Defects in workmanship beyond the limitations specified herein shall constitute cause for rejection.

4. QUALITY ASSURANCE PROVISIONS

4.1 Responsibility for inspection. Unless otherwise specified in the contract, the contractor is responsible for the performance of all inspection requirements as specified herein. Except as otherwise specified in the contract, the contractor may use his own or any other facilities suitable for the performance of the inspection requirements specified herein, unless disapproved by the Government. The Government reserves the right to perform any of the inspections set forth in the specification where such inspections are deemed necessary to assure supplies and services conform to prescribed requirements.

MIL-B-24222A (SH)

4.2 Classification of inspections. The inspection requirements specified herein are classified as follows:

- (a) First article inspection (see 4.3).
- (b) Quality conformance inspection (see 4.4).

4.3 First article inspection. First article inspection shall consist of the examination specified in 4.5.1 through 4.5.1.2. The contractor shall prepare a first article inspection report in accordance with the data ordering document included in the contract or order (see 6.2.2).

4.4. Sampling for quality conformance inspection. Unless otherwise specified herein, sampling for quality conformance inspection shall be performed in accordance with MIL-STD-105. For purposes of sampling, an inspection lot for examinations shall consist of all material offered for delivery at one time, not to exceed 100 units per lot.

4.5 Examination of bag.

4.5.1 Examination of the bag shall be made in accordance with the classification of defects, inspection levels and acceptable quality levels (AQLs) set forth in 4.5.1.4. The lot size for purpose of determining the sample size in accordance with MIL-STD-105, for examinations in 4.5.1.1 and 4.5.1.2, shall be expressed in units of bags. For examination in 4.5.1.3 the lot size shall be expressed in units of shipping containers. Any bag in the sampling containing one or more defects shall not be offered for delivery. If the number of defective bags in any sample exceeds the acceptance number for that sample, this shall be cause for rejection of the lot represented by the sample.

4.5.1.1 Examination of the bag for defects in material, construction, appearance and workmanship.

<u>Examine</u>	<u>Defect</u>
Material	Bag not colored cloth as specified. Thread not nylon of type class and size specified. Drawcord not nylon rope as specified. Grommet not rolled ring with spur washer; not brass, bright finish.
Construction and appearance	Any component missing or malformed. Side not made of one piece material. Bottom not made of one piece material. Material not lapped at all seams; seam width not as specified (see figure 1). Any detail of construction and design not as specified. Any hole, cut, tear or other fabric defect affecting appearance or serviceability. Any cut, fray or abrasion in drawstring. Stitching not type specified for applicable seam or attachment.
Workmanship	Any open seam. Grommet improperly located. Warp not parallel with length of bag. Drawstring not knotted as specified (see figure 1). Grommet not securely and uniformly compressed into material. Any burr or rough edge or grommet not ground smooth. Not clean.
Marking	Omitted, incomplete, incorrect or illegible.

4.5.1.2 Examination for dimensional defects. One bag shall be examined as follows:

<u>Examine</u>	<u>Defect</u>
Overall dimensions	Not within tolerance specified (see figure 1).
Seams	Width not as specified.
Stitching	Number of threads per inch not as specified.
Grommet	Not 14 grommets per bag; (see figure 1).
Drawstring	Not 3/16 inch in diameter.

MIL-B-24222A(SH)

4.5.1.3 Examination of preparation for delivery. One shipping container fully packed, selected just prior to the closing operations shall be examined as follows. Shipping containers, fully prepared for delivery, shall be examined for closure defects.

<u>Examine</u>	<u>Defect</u>
Material	Any component or material not as specified. Any component missing, torn or malformed.
Packaging (level A)	Each bag not flattened as specified, with draw-string ends inside the bag; bag bottom not folded in half with the material positioned between the tube (side) walls.
Packing	Not the specific or indicated quantity of bags specified or indicated per shipping container. Insufficient or inadequate application of components such as incomplete or insecure closure of Kraft paper wrapper, case liner or container flaps, as applicable; loose, crooked, or insecure strapping or tape banding; bulge or distortion of shipping container. Broken, bruised, crushed or otherwise damaged shipping container in a manner which could result in loss or injury to contents.
Marking (interior packages and shipping containers)	Omitted, incomplete, incorrect, illegible; of improper size location or sequence of application.
Gross weight	In excess of weight limitation of the applicable box specification for fiber boxes.

4.5.1.4 Inspection levels for the purpose of determining the sample size and the acceptable quality levels (AQL) expressed in defects per 100 units shall be as follows:

<u>Examination paragraph</u>	<u>Inspection levels</u>	<u>AQL</u>
4.5.1.1	I	2.5
4.5.1.2	II	2.5
4.5.1.3	III	6.5

5. PREPARATION FOR DELIVERY

(The preparation for delivery requirements specified herein apply only for direct Government procurements. For the extent of applicability of the preparation for delivery requirements of referenced documents listed in section 2, see 6.4.)

5.1 Preservation-packaging. Preservation-packaging shall be Level A or C as specified (see 6.2.1).

5.1.1 Level A. Each bag shall have its drawcord in a released or loosened condition and placed inside the bag. Each bag shall be flattened, bag bottom shall be folded in half with the material positioned between the bag (side) walls and the bag folded in half length wise. Each folded bag shall then be placed within a plastic bag of minimum 4 MIL thickness. The plastic bag shall be sealed by heat sealing.

5.1.2 Level C. Each bag shall be packaged in a manner to afford protection against damage during shipment from the contractor's source to first using activity for immediate use. Packaging may conform to the contractors normal retail procedure when such meets the requirements of this level.

5.2 Packing. Packing shall be level A, B, or C as specified (see 6.2.1).

5.2.1 Level A. Twenty four bags, packaged as specified (see 5.1) shall be packed in a fiberboard container conforming to PPP-B-636, Class 2 - Water-resistance, or PPP-B-640 Class 2 - Weather resistant at the contractors option. Other options provided in the selected a specification unless otherwise specified herein shall be at the contractor's option. Boxes conforming to PPP-B-636 shall be closed, waterproofed and reinforced in accordance with method V of the appendix to PPP-B-636. Boxes conforming to PPP-B-640 shall be closed, sealed and reinforced in accordance with the appendix to PPP-B-640 except that reinforcing shall be accomplished with nonmetallic strapping in lieu of steel straps.

MIL-B-24222A (SH)

5.2.2 Level B. Twenty-four bags packaged as specified (see 5.1), shall be packed in a fiberboard container conforming to PPP-B-636, Class-Domestic, or PPP-B-640, Class 1 - Non-weather resistant at the contractor's option. Other options provided in the selected specifications unless otherwise specified herein shall be at the contractors option. Boxes shall be closed in accordance with the appendix to the applicable box specification.

5.2.3 Level C. Twenty four bags packaged as specified (see 5.1) shall be packed in containers in a manner which will insure acceptance by common carrier at the lowest rate and will afford protection against damage during shipment from the supply source to the first using activity for immediate use. Containers, packing or method of shipment shall conform to the Uniform Freight or National Motor Freight Classification Rules or Regulations or other carrier rules as applicable to the mode of transportation.

5.3 Marking. In addition to any special marking required (see 6.2.1 and 3.8) unit packages and shipping containers shall be marked in accordance with MIL-STD-129.

6. NOTES

6.1 Intended use. The storage bags covered by this specification are intended for use in storing air line masks and hoses.

6.2 Ordering data.

6.2.1 Procurement requirements. Procurement documents should specify the following:

- (a) Title, number, and date of this specification.
- (b) Color of storage bag cloth as specified (see 3.2.1).
- (c) Level of packaging, packing, and marking (see 5.1 and 5.2).
- (d) Special marking required (see 5.3).

6.2.2 Data requirements. When this specification is used in a procurement which invokes the provision of the "Requirements for Data" of the Armed Services Procurement Regulations (ASPR), the data identified below, which are required to be developed by the contractor, as specified on an approved Data Item Description (DD Form 1664), and which are required to be delivered to the Government, should be selected and specified on the approved Contract Data Requirement List (DD Form 1423) and incorporated in the contract. When the provisions of the "Requirements for Data" of the ASPR are not invoked in a procurement, the data required to be developed by the contractor and required to be delivered to the Government should be selected from the list below and specified in the contract.

<u>Paragraph</u>	<u>Data requirements</u>	<u>Applicable DID</u>	<u>Option</u>
4.3	Report, first article inspection	UDI-T-23450	---

(Copies of data item descriptions required by the contractors in connection with specific procurement functions should be obtained from the procuring activity or as directed by the contracting officer. Unless otherwise indicated, the issue in effect on date of invitation for bids or request for proposal shall apply.)

6.2.2.1 The data requirements of 6.2.2 and any task in section 3, 4, or 5 or the specification required to be performed to meet a data requirement may be waived by the procuring/purchasing activity upon certification by the offeror that identical data were submitted by the offeror and accepted by the Government under a previous contract for identical item procured to this specification. This does not apply to specific data which may be required for each procurement regardless of whether an identical item has been supplied previously (for example, test reports).

6.3 First article inspection. Invitations for bids should provide that the Government reserves the right to waive the requirement for samples for first article inspection as to those bidders offering a product which has been previously procured or tested by the Government, and that bidders offering such products, who wish to rely on such production or test, must furnish evidence with the bid that prior Government approval is presently appropriate for the pending procurement.

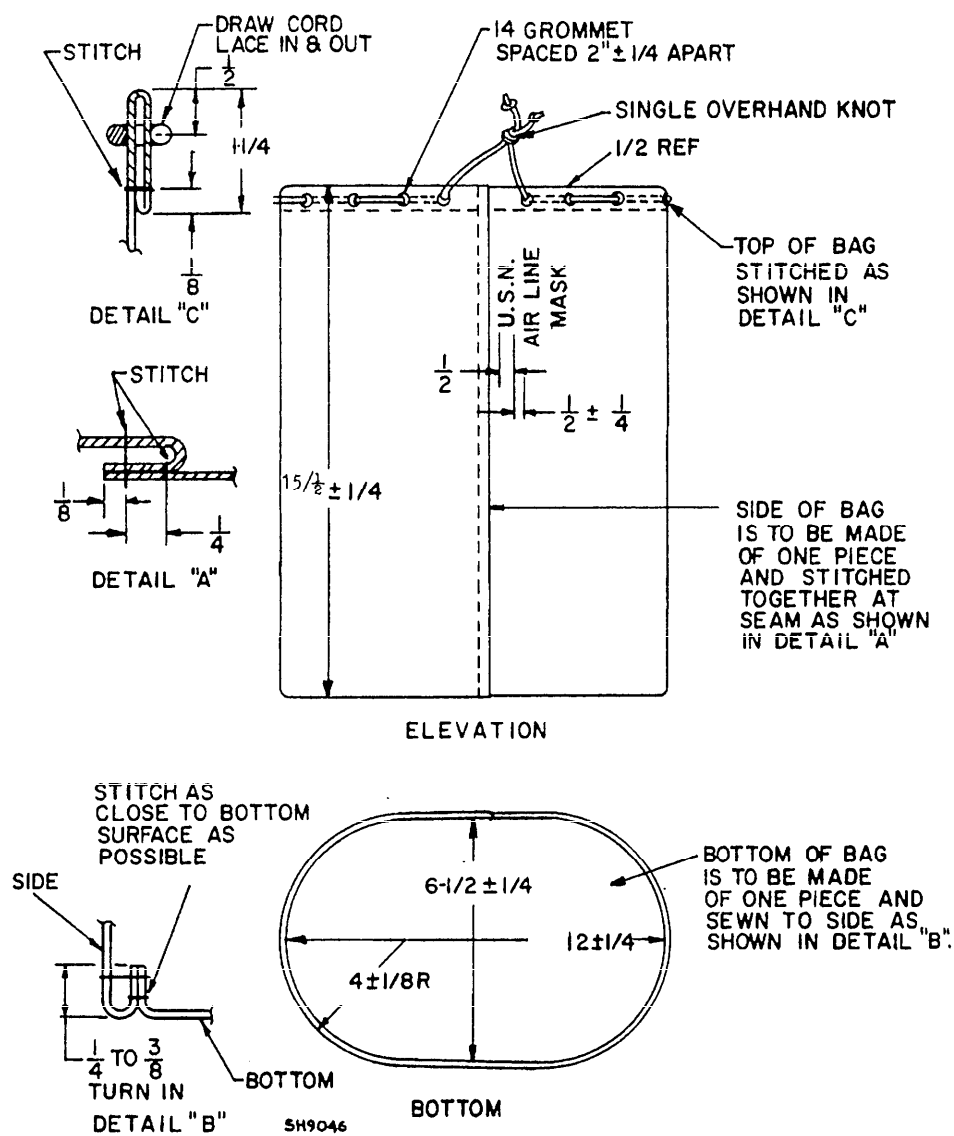
6.4 Sub-contracted material and parts. The preparation for delivery requirements of referenced documents listed in Section 2 do not apply when material and parts are procured by the contractor for incorporation into the equipment and lose their separate identity when the equipment is shipped.

MIL-B-24222A(SH)

6.5 Changes from previous issue. The symbol "#" is not used in this revision to identify changes with respect to the previous issue, due to the extensiveness of the changes.

Preparing activity:
Navy - SH
(Project 2090-N076)

MIL-B-24222A (SH)

FIGURE 1. Dimensions and construction.

FOLD

COMMANDER
NAVAL SHIP ENGINEERING CENTER (SEC 6124)
DEPARTMENT OF THE NAVY
WASHINGTON, D.C. 20362

OFFICIAL BUSINESS
PENALTY FOR PRIVATE USE \$300

POSTAGE AND FEES PAID

DEPARTMENT OF THE NAVY

DOD 316



COMMANDER
NAVAL SHIP ENGINEERING CENTER (SEC 6124)
DEPARTMENT OF THE NAVY
WASHINGTON, D.C. 20362

FOLD